



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4704-041
Job Sheet 164487



Part No: D4704-041

Job Qty: 2 ea

Part Name: Expandable Pin Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B SHEET 1 IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS IPP REV:B 12.10.16 AS PER DWG REV:A DD VERF:JFS IPP REV:C 17.01.11AS PER DWG REV.B PRELIM DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D4704-041 Expandable Pin Assembly	DWG REV B SHEET 1 IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS IPP REV:B 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:C 17.01.11AS PER DWG REV.B PRELIM DD VERF:JLM		0.000	
D4708-1 Lanyard	DWG REV C IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS		0.000	
D4709-1 Spring Clip	DWG REV C SHEETS 1,2 IPP REV:A 12.09.11 NEW ISSUE DD VERF:JLM		0.000	
D4711-041 Expandable Pin Assembly, Modified	DWG REV D IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B 13.03.11 AS PER DWG REV.C DD VERF:JFS		0.000	
MS20613-4C8 Rivet			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	2 Ea	10/30/17	0.00	0.00	Start up container	
110	Packaging	2 pcs	10/30/17	0.00	0.00	Packaging1	
120	Small Fab	2 pcs	10/31/17	0.00	0.62	Small Fab	38
130	QC	2 pcs	10/31/17	0.00	0.00	QC5	38
140	Packaging	2 pcs	10/31/17	0.00	0.00	Packaging3	9-88
150	QC21-SA	2 Ea	10/31/17	0.00	0.00	QC21	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4708-1 F150504	2	0	0	0
	D4709-1 F164380	4	0	0	0
	D4711-041 S013124	4	0	0	0
	MS20613-4C8 F120242-4084x		0	0	0

MS20613-4C7 F1138043 4x

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S013201

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1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
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Expandable Pin Assembly

PART NO: D4704-041

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/24/17

Job No: 164487

Work Order ID 164487

164487

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Wednesday, July 19, 2017 2:41:43 AM

Item ID: D4704-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Expandable Pin Assembly
 Start Date: 7/20/2017 Start Qty: 2.00 *?
 Required Date: 7/24/2017 Req'd Qty: 2.00 *?
 Cust Item ID:
 Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-29 Date: JUL 20 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4704	B

110	Pick Kit	0.00							
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110

Packaging	Memo	0.00							
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Packaging									
-----------	--	--	--	--	--	--	--	--	--

120

120

Small Fab									
-----------	--	--	--	--	--	--	--	--	--

Small Fab	Memo								
-----------	------	--	--	--	--	--	--	--	--

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC	Memo	0.04							
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Quality Control

D4711-041
X24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

Work Order ID 164487

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164487

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Item ID: D4704-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Expandable Pin Assembly

Stop *NS2*

Start Date: 7/20/2017 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 7/24/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

140

Identify as per dwg & Stock Location:

0.00

140

Packaging

Memo

0.02

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.20

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due								
		☐ OTHER :							

Picklist Print

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Work Order ID: 164487

164487

Parent Item: D4704-041

D4704-041

Parent Item Name: Expandable Pin Assembly

Start Date: 7/20/2017

Required Date: 7/24/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS IPP REV:B
12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:C 17.01.11AS
PER DWG REV.B PRELIM DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4708-1 *D4708-1* Lanyard		Manufactured	No			110	Each	14.0000	1	2			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST120				14					
					150504			14					
D4709-1 *D4709-1* Spring Clip		Manufactured	No			110	Each	5.0000	2	4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST120				5					
					161874			5					
D4711-041 *D4711-041* Expandable Pin Assembly, Modified		Manufactured	No			110	Each	0.0000	2	4			
MS20613-4C8 *MS20613-4C8* Rivet		Purchased	No			110	Each	123.0000	4	8			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				123					
					120242			123					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
OTHER : ☐									